



Dart Aerospace Ltd.
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K6A 1K7
Canada

Tel (613) 632-5200

D3016-5
Job Sheet 170496



Part No: D3016-5

Job Qty: 16 ea

Part Name: Tube



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/16/18

Job Tracking No:

Due Date: 2/2/18

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV A IPP REV:A 16.08.31 NEW PROCESS DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	16 Ea		2/1/18	0.00	0.00	Start Up Large Fab-7		J.C.-L.
110	Large Fab	16 pcs		2/1/18	0.00	1.60	Cold Saw		J.C.-L.
120	Mill Conv	16 pcs		2/2/18	0.00	8.00	Mill Conv 1		J.C.-L.
130	QC	16 pcs		2/2/18	0.00	0.00	QC2 Machining-1		J.C.-L. 18-01-31
140	QC	16 pcs		2/2/18	0.00	0.00	QC8 Machining-1		18/02/05
150	Packaging	16 pcs		2/2/18	0.00	0.00	Packaging3-1		EL
160	QC21-SA	16 Ea		2/2/18	0.00	0.00	QC21		DAS

Part Op 110 - Cut material to 14.06"

Descriptions: 120 - USE TOOLING DT10265

21 FEB 06 2018
9:00

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M4130NT0.500W.049	19	117	0	0
	1129826 → 19.078'				

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Tube	13.800Inches ± 0.030	13.830 13.770		13.801
2	Tube	74.000Degrees ± 0.500	74.500 73.500	Angle	74.01
3	Tube	0.380Inches ± 0.030	0.410 0.350	Radius	0.375

J.C.-L. 18-01-31

Plex 1/16/18 4:05 PM dart.poulin.mario

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Date : _____	Step #: _____	QTY Effective : _____			MRB (QSI042) Approval
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor Approval Verification

Root Cause		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐
Design ☐	Operator ☐	Bending ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐
Material ☐	Use for Testing ☐	Cuffs ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐
Past Expiry Date ☐	Manufacturing Process ☐	
Misidentified ☐	Past Due ☐	OTHER : ☐

Job No: 170496

Start up Operation 01/31/18

Change No:

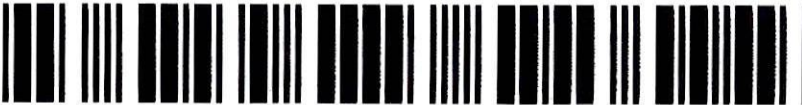
Operation:

Revision:

PART NO: D3016-5

Original Serial #: S037383

Tube



S037383

DART AEROSPACE

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